

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020779**Date Inspected:** 07-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr.Wu Zhi Chang .**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

SEGMENT # 9AE :

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG052A-021. Welding Repair

Report(WR)B-WR-13818, Welder is identified as 048659. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

Flux Cored Arc Welding(FCAW) of the weld joint SEG054A-014(BP to SP,9BE to 9CE).Welding Repair Report (WR)B-WR-13818 Welder is identified as 220069. ZPMC Quality Control (QC) is identified as Mr.An Qing Xing. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2231T-1.

FCAW Welding of the weld joint SSD27-P075-39/40,43/44,49/50,111/112,119/120,121/122,125/126. Welder is identified as 222396. ZPMC Quality Control (QC) is identified as Mr.Liu Hua Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132-FCM-1.

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FCAW Welding of the weld joint SSD27-P075-41/42,33/34, Welder is identified as 220066. ZPMC Quality Control (QC) is identified as Mr.Liu Hua Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2133-FCM-1.

Segment #9W

Flux Cored Arc Welding (FCAW) welding of weld joint SEG051C-068(Before it was 07&08 fillet weld but engineer made changes to CJP Because the root gap was 7.5mm, So that joint is Rewelded As per Engineer Approval No-B-JC-60R0), Welder is identified as 066326. ZPMC Quality Control (QC) is identified as Mr.Shi Lei. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2212-TC-U4b-FCM-1.

During Surveillance inspection found excavation for the Weld OBW9B-04/05(SP to SP,9AW + 9BW) As Per Welding Repair Report no-B-WR-13931, And To fix the misalignment.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
